



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2935
Job Sheet 168076



Part No: D2935

Job Qty: 30 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Job Created: 11/9/17

Due Date: 11/11/17

Type: Stock

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP A 00-06.06 New Issue EC IPP Rev:B Now 6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		11/10/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	30 pcs		11/10/17	0.00	0.78	Waterjet1		SC
120	QC	30 pcs		11/10/17	0.00	0.00	QC8		38
130	HandFinish	30 pcs		11/11/17	0.00	0.33	HandFinish1		2017-11-16 JSL
140	QC	30 pcs		11/11/17	0.00	0.00	QC7		38
150	Packaging	30 pcs		11/11/17	0.00	0.00	Packaging3	51014	51 NOV 21 2017
160	QC21-SA	30 Ea		11/11/17	0.00	0.00	QC21		NOV 21 2017

Part Op
Descriptions: 100 - 1-Cut as per Dwg D2935

21
9-89

NOV 21 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.080	2	69	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Saddle Spacer	3.910Inches ± 0.030	3.940 3.880		
3	Saddle Spacer	1.354Inches ± 0.010	1.364 1.344		
4	Saddle Spacer	0.250Inches ± 0.010	0.260 0.240		
5	Saddle Spacer	0.250Inches ± 0.030	0.280 0.220	Radius	

Plex 11/10/17 12:37 PM dart.lacelle.linda

DART
AEROSPACE
S010433



Saddle Spacer

PART NO:
Revision:
Operation:
Change No:

D2935

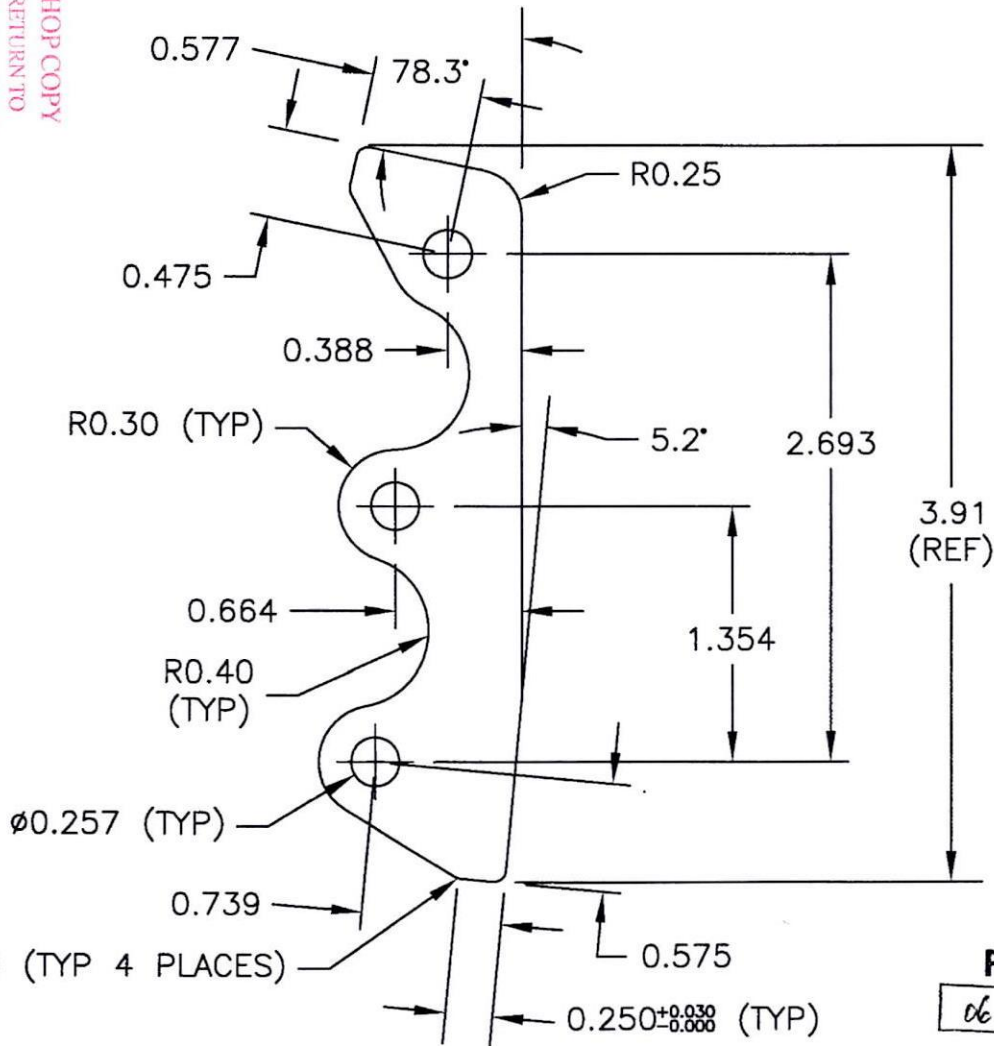
Start up Operation

Mfg Date: 11/15/17
Job No: 168076

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART

DESIGN JF	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED****NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 1999 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 168076
WORK ORDER

DAS
30
9-89

NOV 13 2017

